

Work Order ID 152185

152185

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Friday, October 21, 2016 3:01:54 PM

Item ID: D3912-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eyebolt
 Start Date: 10/28/2016 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 11/3/2016 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: OCT 26 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								

100 0.00

100

Doosan

Memo

0.62

Doosan Lathe

TURN AS PER FOLIO FA871AND DWG

Prog Rev: 0

Dwg Rev: 6

Deburr as required

10 2 16-12-5

PTO →

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.01

Quality Control

16-12-5

DQA:

Date:

JAN 3 2017

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed

Date:

Work Order update only

Work Order: <u>152185</u> Part No. <u>D3912-1</u> NCR No. <u>16-6170</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date: <u>16-12-5</u>		Step #: <u>100</u>		QTY Effective: <u>2</u>		MRB (QSI042) Approval DAS <u>9</u> <u>16-12-06</u>	
Description Work Order Deviation				Disposition			
2 parts are scrap, end-mill pulled out of collet causing thicknesses to be under tolerance				Scrap + replace <u>B135687</u> - changed collet for welded holder and added a note in program to do so			
				Completed By <u>JK</u> <u>16-12-5</u>			
				Lead hand / Supervisor Approval Verification <u>JK</u> <u>16-12-05</u>			
				QC / QA Coordinator Approval <u>JK</u> <u>DEC 05 2016</u>			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ ☒ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☒ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Mismatched/off center ☐ Turning Sequence ☐			
OTHER :							

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Item ID: D3912-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyebolt
Start Date: 10/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/3/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.02				<u>10</u>	<u>2</u>		DAS 44 9-89 16-12-08
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>stos</u> Memo	0.00 0.01				<u>10</u>		DEC 13 2016	DAS 6 9-89
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10						DEC 14 2016	DAS 21 9-89

MF
16-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Work Order ID: 152185

152185

Parent Item: D3912-1

D3912-1

Parent Item Name: Eyebolt

Start Date: 10/28/2016

Required Date: 11/3/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	9.5000	0.25	1.578947			

M303R2 000

303 ROUND BAR 2"

10/12-5

Location

Loc Qty

Loc Code

MAT028

9.5

m135687

9.5

3.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

DART AEROSPACE LTD		Work Order:	152185
Description: Eyebolt		Part Number:	D3912-1
Inspection Dwg: D3912 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

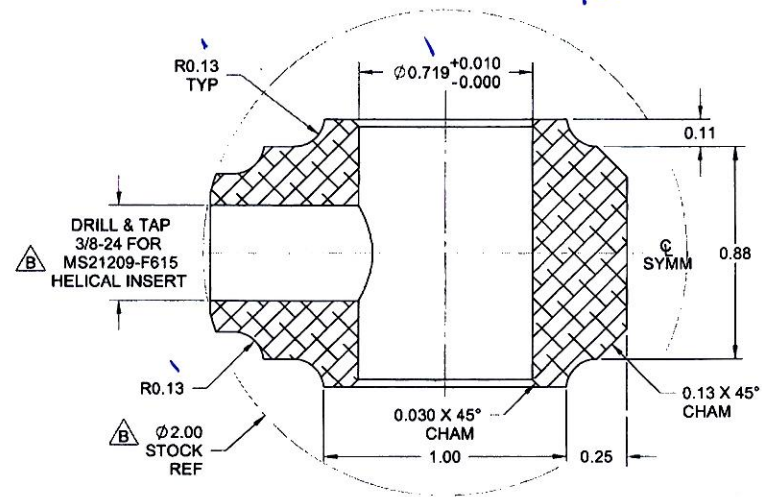
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.125	✓		VPRJ5	2.10
Ø0.700	+/-0.010	.697	✓			
Ø0.500	+/-0.010	.497	✓			
0.90	+/-0.030					
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	✓			
0.22	+/-0.030	.220	✓			
0.75	+/-0.030	.750	✓			
0.970	+/-0.010	.970	✓			
1.72	+/-0.030	1.719	✓			
1.20	+/-0.030	1.197	✓			
0.625	+/-0.010	.625	✓			
2.23	+/-0.030	2.227	✓			
R0.13	+/-0.030	R.130	✓			
R0.015	+/-0.010	R.015	✓			
0.625	+/-0.010	.624	✓			
Ø0.650	+/-0.010	.650	✓			
1.100	+/-0.010	1.099	✓			
0.44	+/-0.030	.440	✓			
R0.13	+/-0.030	R.125	✓			
1.00	+/-0.030	1.000	✓			
0.25	+/-0.030	.251	✓			
0.88	+/-0.030	.880	✓			
0.11	+/-0.030	.110	✓			
Ø0.719	+0.010/-0.000	.7235	✓			

Measured by:	JK
Date:	16-12-05

Audited by:	DAS 44 9-89
Date:	16-12-08

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	



NO. 152185 MLJ 1610-26

SECTION A-A B6-3

RELEASED
2010-07-16

7) WEIGHT: 0.45 lbs

D3912-1 EYEBOLT

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>1/1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1/1</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1/1</i>	D3912	SHEET 2 OF 3
APPROVED	<i>1/1</i>	TITLE	SCALE
DE APPR.	<i>1/1</i>	EYEBOLT RECEIVER ASSY	NTS
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